

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013894**Date Inspected:** 04-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Larry Viars was present during the times noted above for observations relative to the work being performed.

West of Bay 19-

This Caltrans QA Inspector observed the following work in progress: Shielded Metal Arc Welding (SMAW) of OBG Segment 9CW weld, FB009-027-025. ZPMC welder was identified as 200569. ZPMC QC was identified as Tan Yai Jun. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2112-FCM-1.

Shielded Metal Arc Welding (SMAW) of OBG Segment 9CW weld, FB015-034-038. ZPMC welder was identified as 067764. ZPMC QC was identified as Tan Yai Jun. ZPMC CWI was identified as Li Yan Hua. The welding appeared to be in conformance with welding procedure specification, WPS-B-P-2112-FCM-1.

Bay 14-

This Caltrans QA Inspector observed the following work in progress: Flux Cored Arc Welding (FCAW) of OBG Segment 12AE longitudinal diaphragm to floor beam weld, SEG3001F-027. ZPMC welder was identified as 058551. ZPMC QC was identified as Zhong Guo Hui. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2233-TC-U4b-F.

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## WELDING INSPECTION REPORT

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Flux Cored Arc Welding (FCAW) of OBG Segment 12AE longitudinal diaphragm to floor beam weld, SEG3001V-049 and 050. ZPMC welders were identified as 055564 and 044801. ZPMC QC was identified as Zhong Guo Hui. ZPMC CWI was identified as Geng Wei. The welding appeared to be in conformance with welding procedure specification, WPS-B-T-2232-TC-U4b-F.

Blast Bay 1-

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 9BW upper interior surface. Areas requiring light grinding were marked for ZPMC personnel. The location of areas requiring weld repair were recorded and placed on on the punchlist for future repair.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150 0042 2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Viars,Larry	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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